



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE350A93-3505-00
Job Sheet 194615



Part No: RBE350A93-3505-00

Job Qty: 6 pcs

Part Name: GIMBAL JOINT EXTRACT TOOL



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 6/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3505-00 Rev 2 IPP Rev. A 19.05.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	6/24/19		0.08	0.30	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	6 pcs	6/24/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
120	QC 8	6 pcs	6/24/19		0.00	0.00	QC 8 - 12		JUN 25 2019
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		



Container No: S193083

Part: RBE350A93 - 3505 - 00
Job No: 194615
Serial No/Batch: S193083
Revision: 2
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
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TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/24/19

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Container No: S193083



Part: RBE350A93 - 3505 - 00

Job No: 194615

Serial No/Batch: S193083

Revision: 2

Inspector:

Exp Date:

Instructions:

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				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130	Packaging 3-1 - Stock - B4B	6 pcs	6/24/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	6 pcs	6/24/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
40
9-89

JUN 25 2019

Dove M.

GA143

DAS
70
9-89

JUN 26 2019

Part Op **100** - (Small Fab) Assemble as per drawing.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90591A161	Hex Nut M8 x 1.25	6 Ea (1 ea)	100-Small Fab - 1	FM13844-7
91611A104	Roll Pin, Ø2mm X 10mm	6 Ea (1 ea)	100-Small Fab - 1	5184137
RBE350A93-3505-00-1	Receiver	6 pcs (1 ea)	100-Small Fab - 1	5186353
RBE350A93-3505-00-3	All Thread	6 pcs (1 ea)	100-Small Fab - 1	5186549

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A161	6	78	0
	91611A104	6	199	0
	RBE350A93-3505-00-1	6	6	0
	RBE350A93-3505-00-3	6	12	0

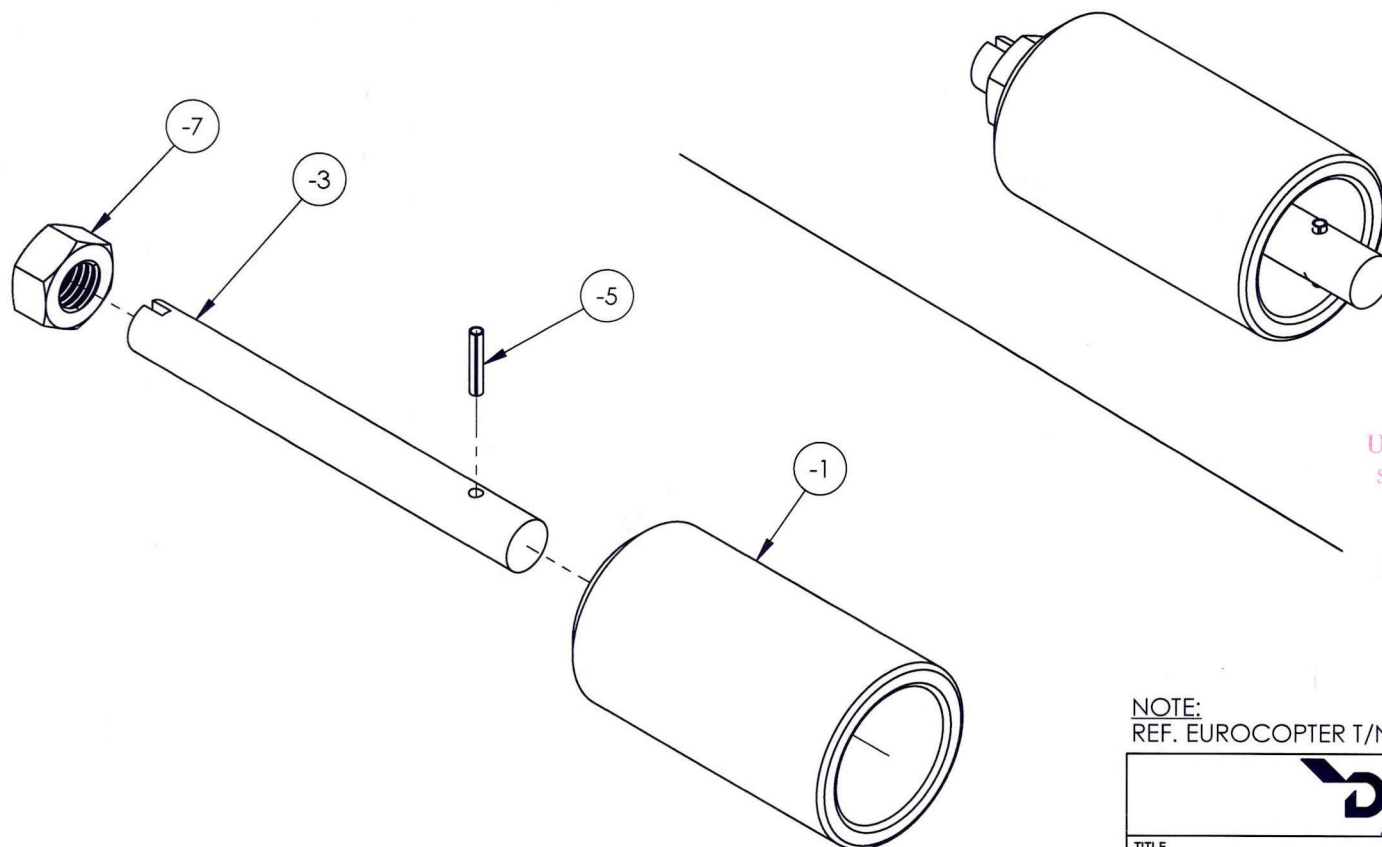
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D -3 SLOT FROM .058 PER D.W.	12/09/2011	RJC	DW
1A		CH'D T/N WAS RBEA93-3505-00 IS RBE350A93-3505-00. -3 CH'D DIMS WAS Ø.079 IS LIMITS Ø.078 TO .082, WAS M8x1.25 IS (M8x1.25), ADDED BLACK OXIDE FINISH. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/29/2014	DPD	RJC
2	16-0200	UPDATED TO NEW STANDARDS. -1 CH'D DIM WAS 1.495 IS 1.995, WAS Ø.828 ∇ 1.19 IS Ø.828 ∇ 1.69, WAS Ø1.103 IS 1.10. -3 CH'D DIM WAS 2.39 IS 2.89, WAS .065 IS .07; ADDED FINISH SPEC.	10/31/2016	SM	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194615 MLC
19-05-06

NOTE:
REF. EUROCOPTER T/N: 350A93-3505-00.

DART AEROSPACE	
TITLE GIMBAL JOINT EXTRACTION TOOL	
DWG NO. RBE350A93-3505-00	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EUROCOPTER 350A
APPROVED: GILBERT	
SCALE 1:1	DATE 6/30/2009 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	6061		2
			-3	1	ALL THREAD	STEEL	M8x1.25 X 61mm (MCMASTER-CARR #99067A248) MODIFIED	3
		B/O	-5	1	ROLL PIN	STEEL	Ø2mm X 10mm (MCMASTER-CARR #91611A104)	1
		B/O	-7	1	HEX NUT	STEEL	M8x1.25 (MCMASTER-CARR #90591A161)	1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					